

Work Order ID 86231

86231

Page 1

June-25-12 10:31:14 AM

Item ID: D3535-21 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 25/06/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 10/07/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/06/25 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B					(13)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
304 .040									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B12-6-26

B12-6-26

8/2/09/27

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86231

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Page 2

June-25-12 10:31:14 AM

Item ID: D3535-21

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearshoe

Stop

NS2

Start Date: 25/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form bend & joggle as per Dwg D3535 using DT8261 & DT8326

13

12/07/04

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/12/04

13

150

150

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40

3200F

8:10

13X

12/07/04

M121279

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June-25-12 10:31:14 AM

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Page 3

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Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 25/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

B ϕ BL 12-7-5.

170

Identify as per dwg & Stock Location: FPI

0.00

170

Packaging

Memo

0.00

Packaging

13X ϕ M-L 12/07/05

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MF 12-07-05

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Picklist Print

June-25-12 10:31:18 AM

Page 1

Work Order ID: 86231

86231

Parent Item: D3535-21

D3535-21

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	352.7693	0.8925	11.27368	12,		
M304S20GA										**			
304/316 .040 Sheet													

B12-6-26

Location	Loc Qty	Loc Code
001	52.4914105	
121192	52.4914105	
MAT020	300.277922	
117933	27.3442	
118400	5.3723	
118964	23.2	
119346	24.8	
121380	49.761422	
121901	169.8	

13

121901

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DART AEROSPACE LTD		Work Order:	86231
Description: Wearshoe		Part Number:	D3535-21
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	✓		V B02	
2.000	+/-0.010	2.000	✓		V	
2.000	+/-0.010	2.000	✓		V	
1.885	+/-0.010	1.890	✓		V	
0.300	+/-0.010	.302	✓		V	
0.300	+/-0.010	.304	✓		V	
5.450	+/-0.010	5.450	✓		T B01	
10.900	+/-0.010	10.900	✓		T	
16.350	+/-0.010	16.356	✓		T	
21.800	+/-0.010	21.800	✓		T	
27.250	+/-0.010	27.256	✓		T	
32.700	+/-0.010	32.700	✓		T	
6.00	+/-0.030	6.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
24.00	+/-0.030	24.02	✓		T	
0.040	+/-0.010	.037	✗		V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	12-6-26	Date:	12/6/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	

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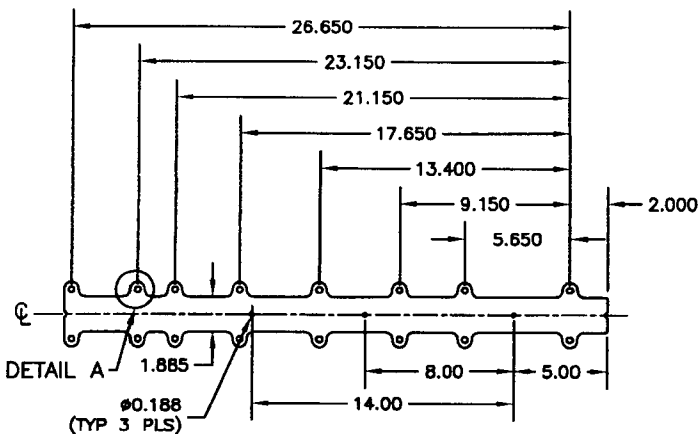
NOTE: Date & initial all entries

DART

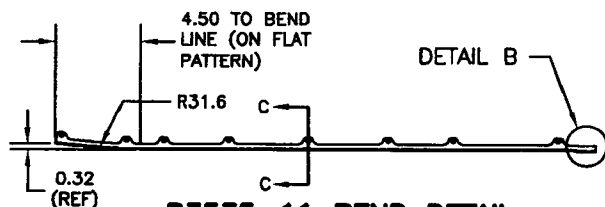
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07.04.17

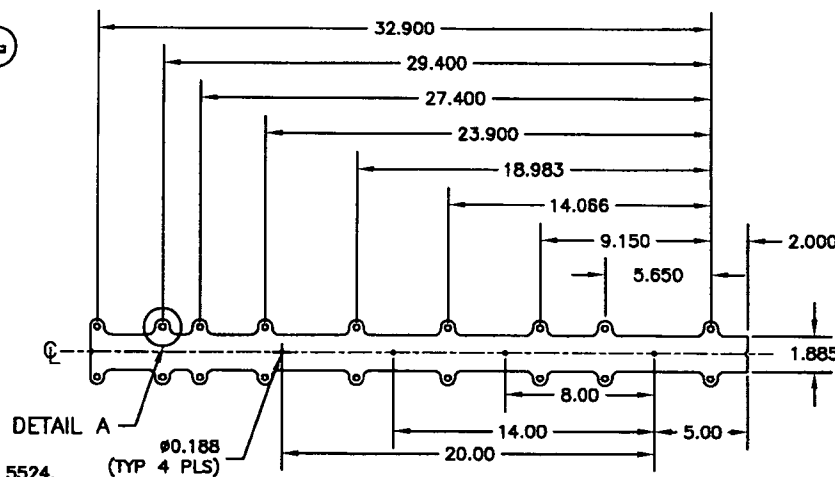
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86231 MLJ
12/06/25



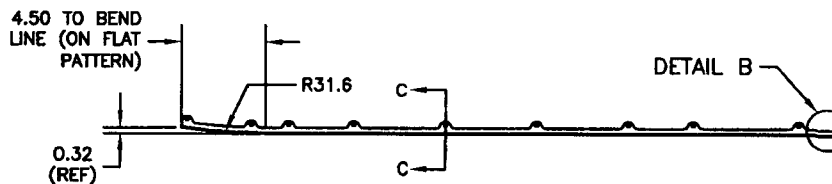
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
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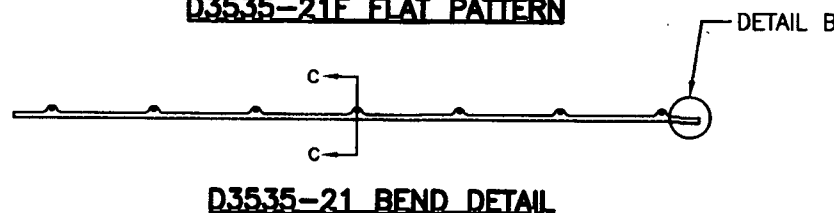
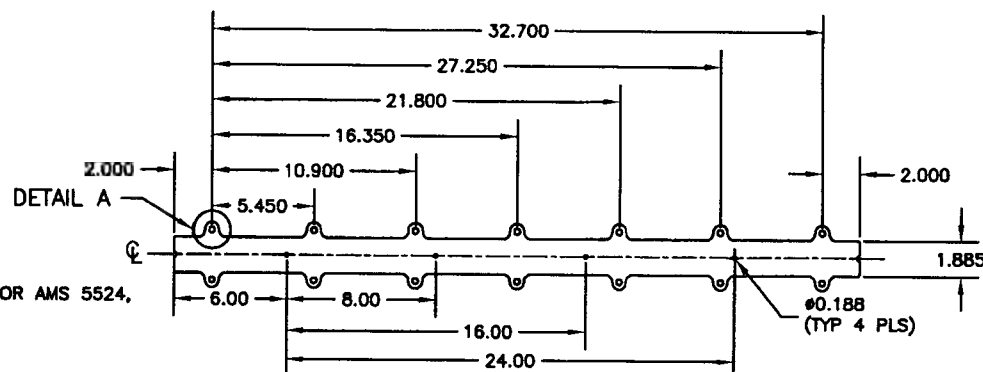
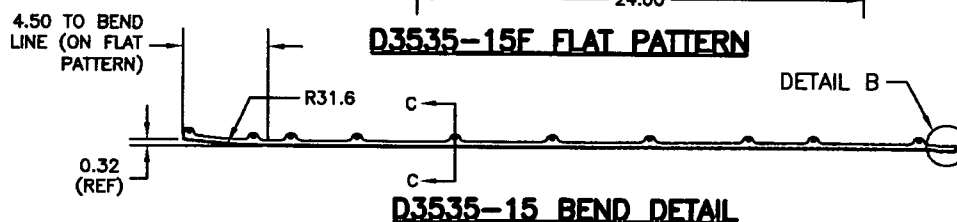
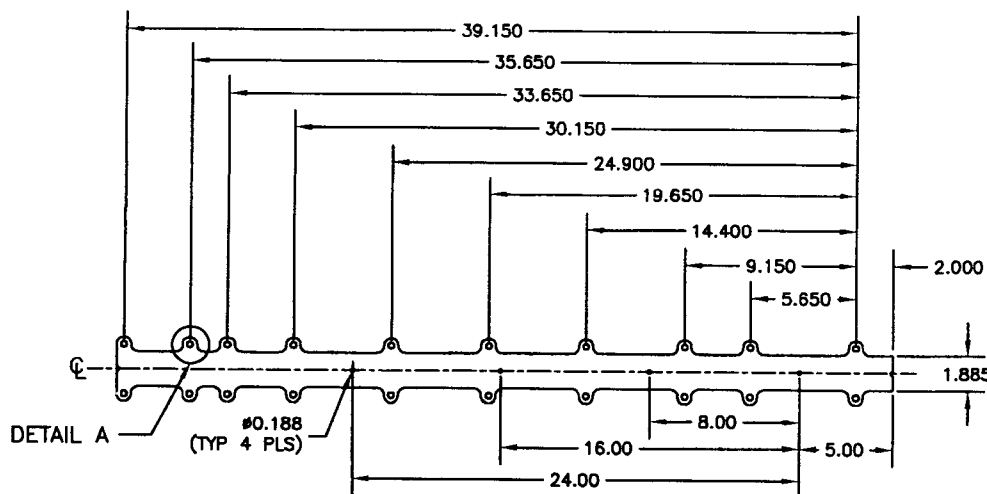
NOTE: Date & initial all entries

86231



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07.04.24

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	SHEET 2 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	



TIPS

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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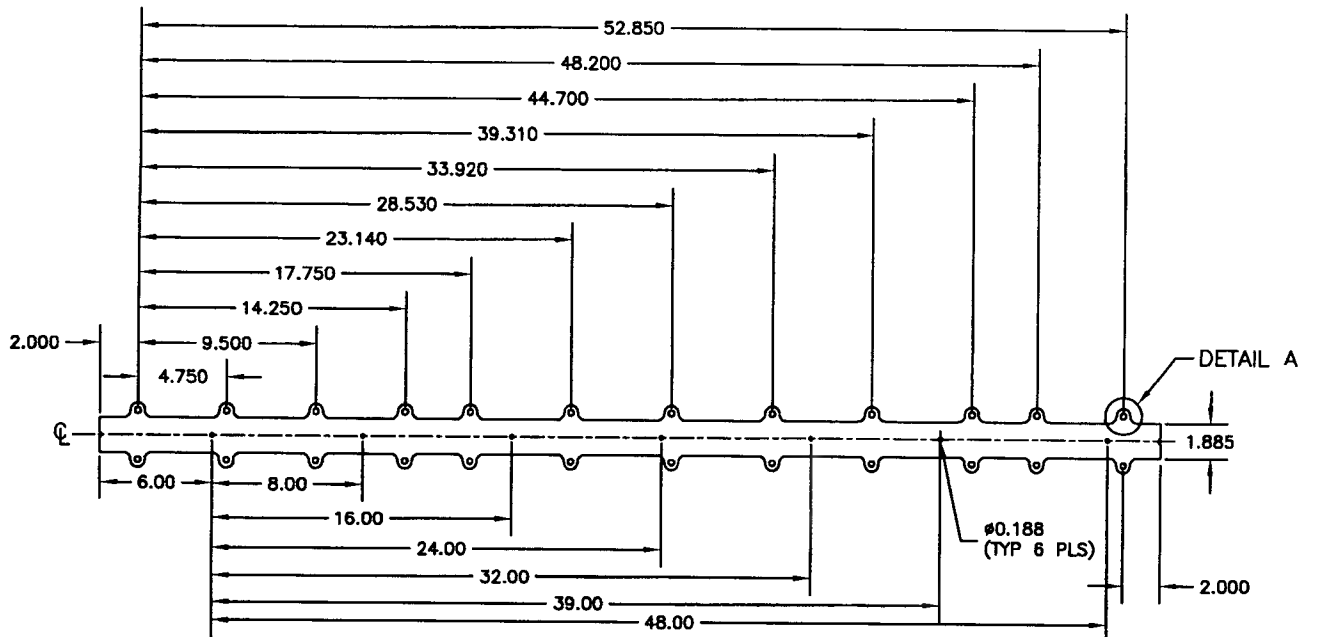
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26231



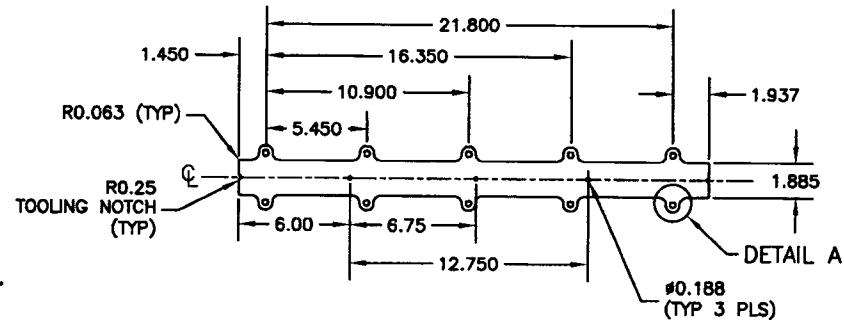
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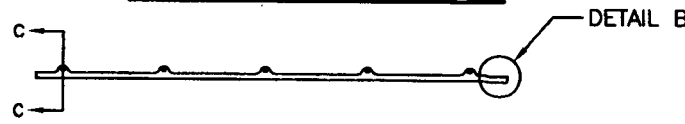
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 3 OF 7
				SCALE 1:10

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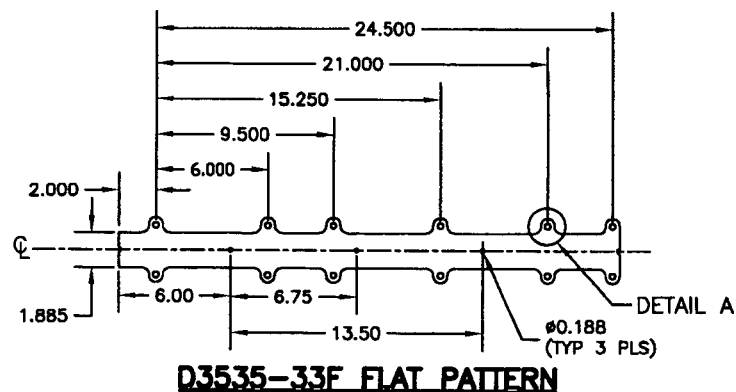
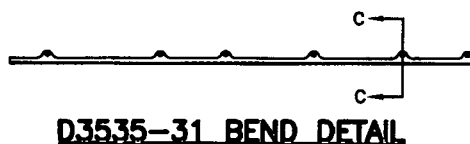
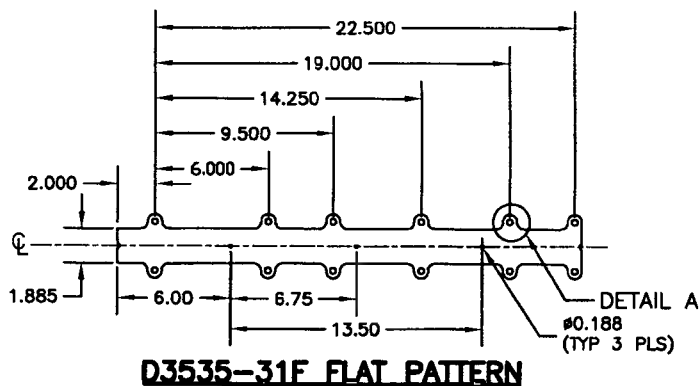
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CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	07.04.17			D3535	SHEET 4 OF 7
				TITLE	SCALE
				WEARSHOE	1:10

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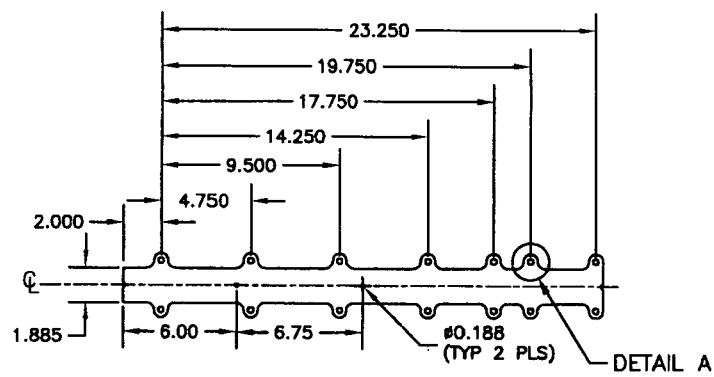
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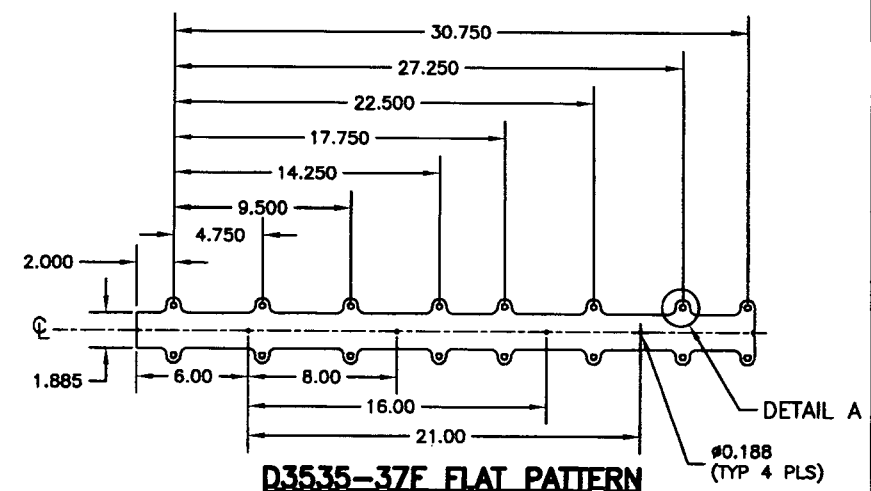
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07.04.17



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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CHECKED		APPROVED		DRAWING NO. D3535	SHEET 5 OF 7
DATE	07.04.17	TITLE	WEARSHOE	SCALE	1:10

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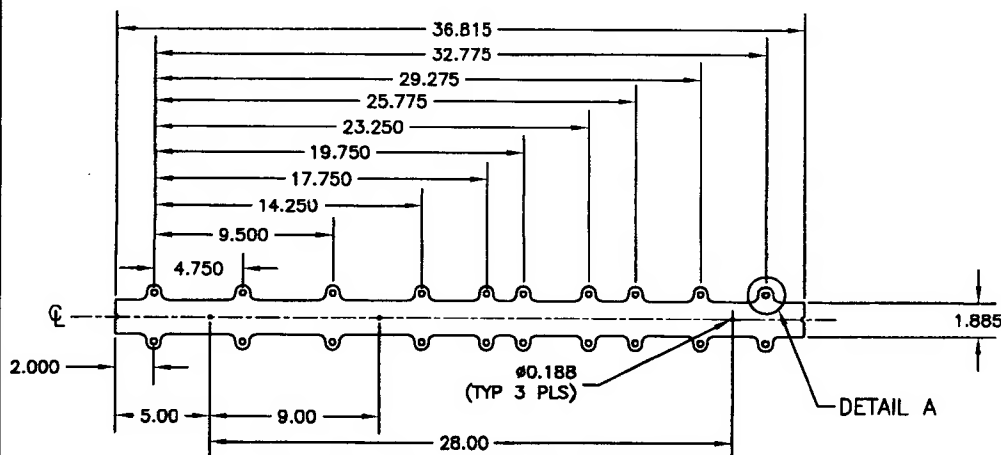
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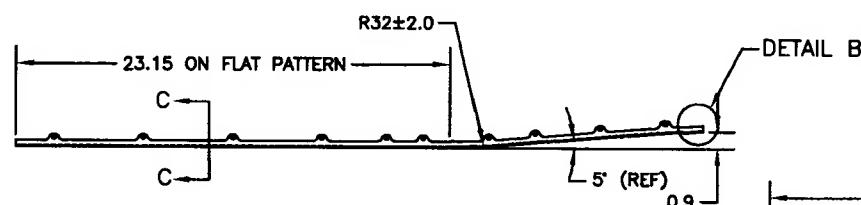
86231



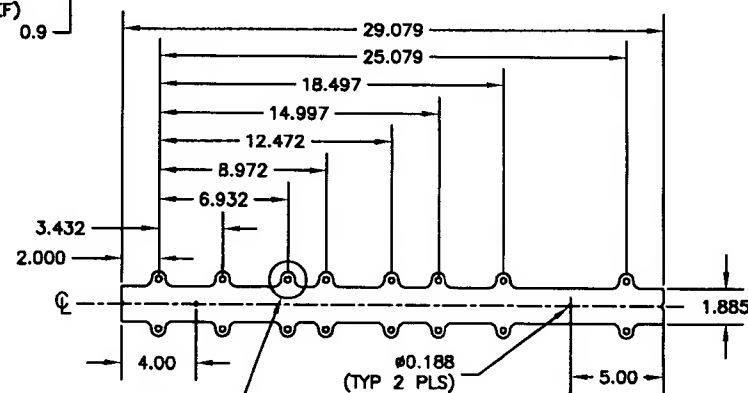
RELEASED
07.04.17



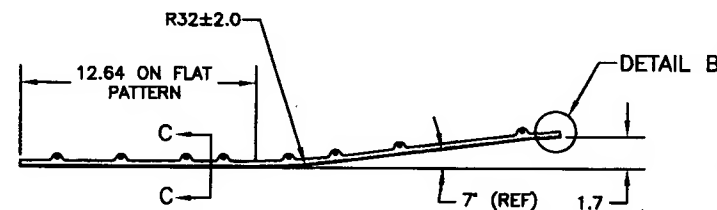
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET 6 OF 7		
SCALE	1:10			

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

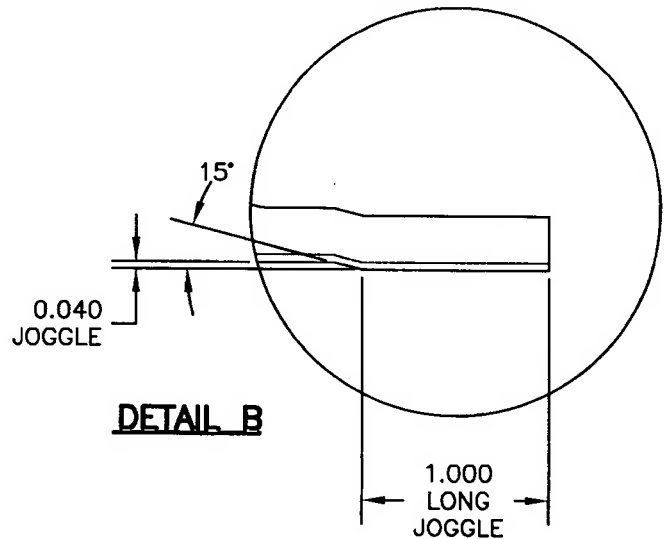
NOTE: Date & initial all entries

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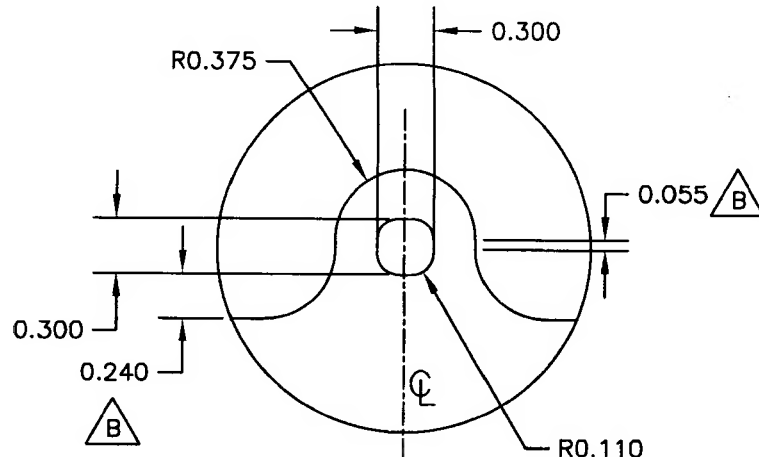


RELEASED
07.04.17

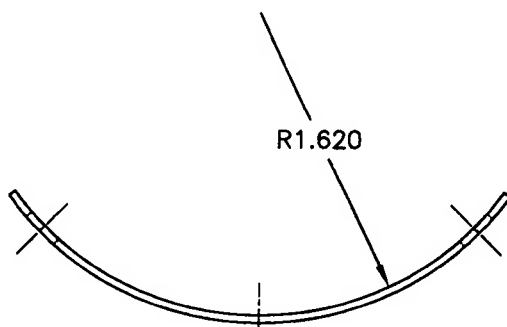
DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
				SCALE 1:1



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries